

Work Order ID 130533

Friday, March 13, 2015 12:59:28 PM

130533*ASAP*

Page 1

Item ID: D5092-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Doubler Assembly

Stop ***NS2***

Start Date: 3/13/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/13/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: MCSDate: 150313

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D5092

B

110

0.00

110

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut D5092-1 as per Dwg

Dwg Rev: BProg Rev: B

2-Deburr if necessary

(12)

DL 15/03/17

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

(12)

DL 15/03/17

Work Order ID 130533

Friday, March 13, 2015 12:59:28 PM

130533

Page 2

Item ID: D5092-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler Assembly
Start Date: 3/13/2015 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 3/13/2015 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							DAS 38 9-89
130						(12)			
QC	Memo	0.00							
Quality Control									MAR 17 2015
133		0.00							
133						12			
Small Fab	Memo	0.00							
Small Fab	C'SINK HOLES AS PER DWG								15/03/17
136	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
136						(12)			
QC	Memo	0.00							
Quality Control									MAR 18 2015

DAS
36
9-89

Work Order ID 130533

Friday, March 13, 2015 12:59:28 PM

130533

Page 3

Item ID: D5092-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler Assembly
Start Date: 3/13/2015 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 3/13/2015 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
140									
Outsource4	Memo	0.00							
Outsource process - Anodize	Issue P/O to ATG : <u>27864</u>								
	1- Black Anodize as per Dwg NOTE 2								
	Certification of Conformity is required								
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									

CL 15/03/23 12

12X SP 15-03-26

(12)

DAS
38
9-89

MAR 26 2015

Work Order ID 130533

Friday, March 13, 2015 12:59:28 PM

130533

Page 4

Item ID: D5092-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Doubler Assembly
 Start Date: 3/13/2015 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 3/13/2015 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		0.00							
170									
Small Fab	Memo	0.00				12X			15/03/2015
Small Fab	INSTALL NUT PLATE AS DWG								
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									
190	Identify as per dwg & Stock Location: st 147	0.00							
190									
Packaging	Memo	0.00							
Packaging									

DAS
27
9-30

MAR 27 2015

DAS
27
9-30

MAR 27 2015

Work Order ID 130533

Friday, March 13, 2015 12:59:28 PM

130533

Page 5

Item ID: D5092-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Doubler Assembly

Stop ***NS2***

Start Date: 3/13/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/13/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

15/3/30
OK 3-30

Picklist Print

Friday, March 13, 2015 12:59:32 PM

Page 1

Work Order ID: 130533

130533

Parent Item: D5092-041

D5092-041

Parent Item Name: Doubler Assembly

Start Date: 3/13/2015

Required Date: 3/13/2015

Start Qty: 6.00

Required Qty: 6.00

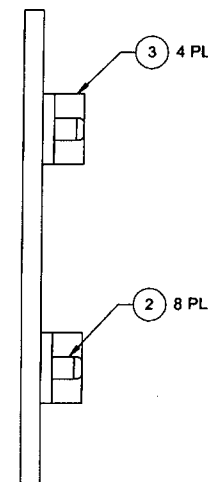
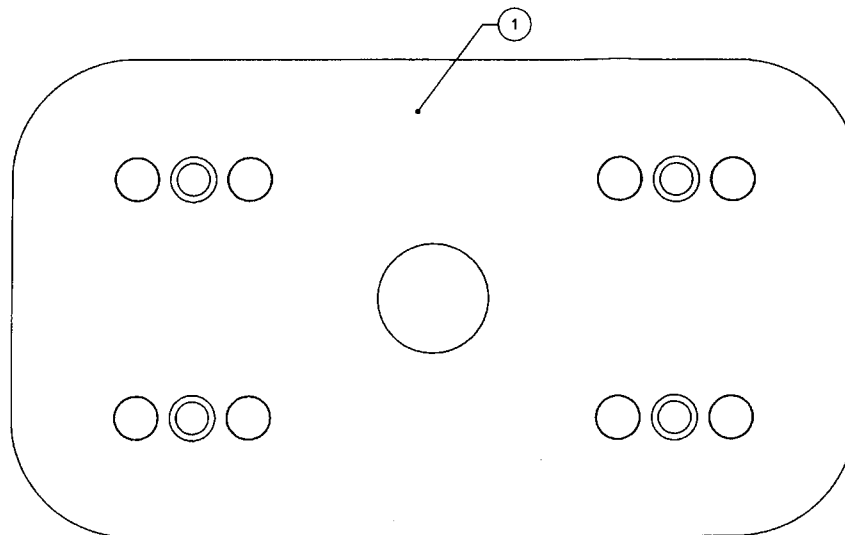
Comments: IPP REV:A 14.11.17 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No				sf	225.8168		1			
M6061T6S 080										**		12/15/03/17	
6061-T6 .080 Sheet													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT020				225.8168					
				m130530				45.5					
				m130560				180.3168					
MS20426AD3-4		Purchased	No				Each	5,108.000		48			
MS20426AD3-4										**		15/03/20	
RIVET													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				CA				12					
				125578				12					
				MF4				19					
				125578				19					
				ST312A				4000					
				m131697				4000					
				ST313				1077					
				m127432				1077					
MS21069L08		Purchased	No				Each	801.0000		24			
MS21069L 08										**		15/03/20	
ANCHOR NUT													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST301				801					
				123522				801					

DAS
36
9-89

DAS
36
9-89

ITEM	QTY -041	P/N	DESCRIPTION
	X	D5092-041	DOUBLER ASSY
1	1	D5092-1	DOUBLER
2	8	MS20426AD3-4	RIVET, SOLID, CSK
3	4	MS21069L08	NUT PLATE, SELF-LOCKING



D5092-041 DOUBLER ASSY

RELEASED
2014-11-06
MD

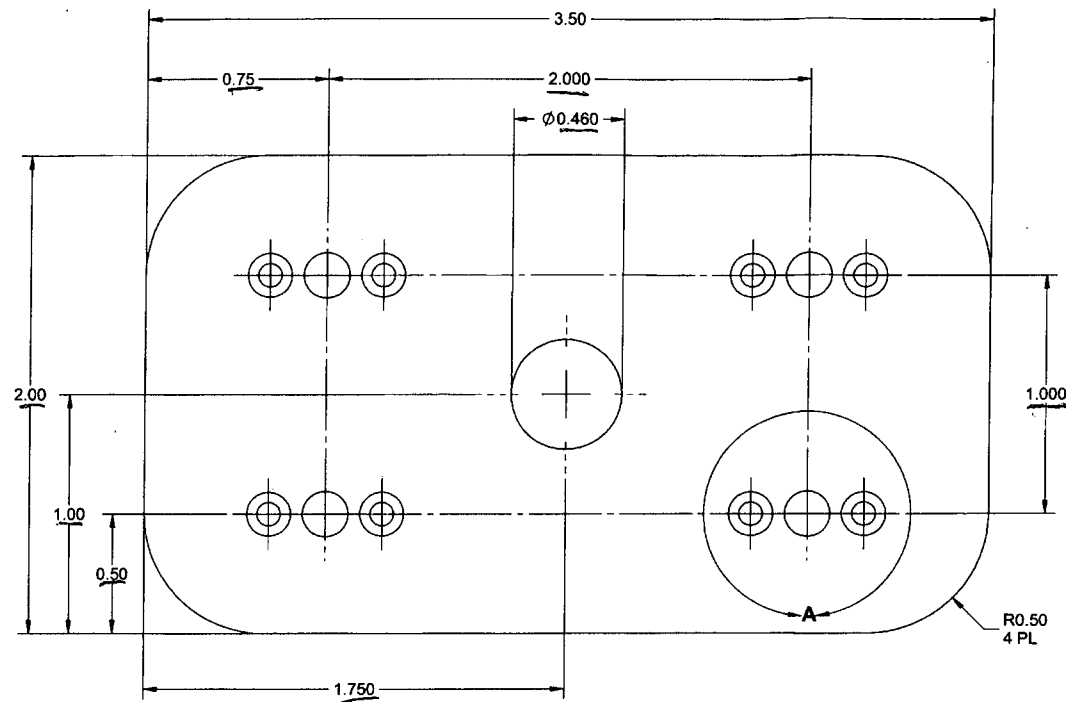
UNCONTROLLED
SUBJECT TO AMENDMENT
NOTICE
130533 MWS
15-03-13

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.1
 - 7) WEIGHT: 0.05 lbs

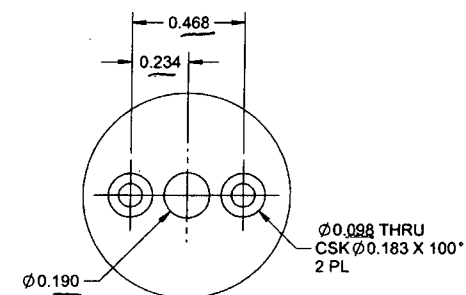
APPROVED

B	MODIFIED DESIGN TO FACILITATE SIMPLER INSTALLATION OF CONTROL CABLE.	ML	14.07.07
A	NEW ISSUE	ML	14.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D5092 DOUBLER COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	AJS		
CHECKED	AP		
MFG. APPR.	JLM		
APPROVED	MP		
DE APPR.	DS	DOUBLER SCALE NTS	
DATE	14.07.07		

A



D5092-1 DOUBLER

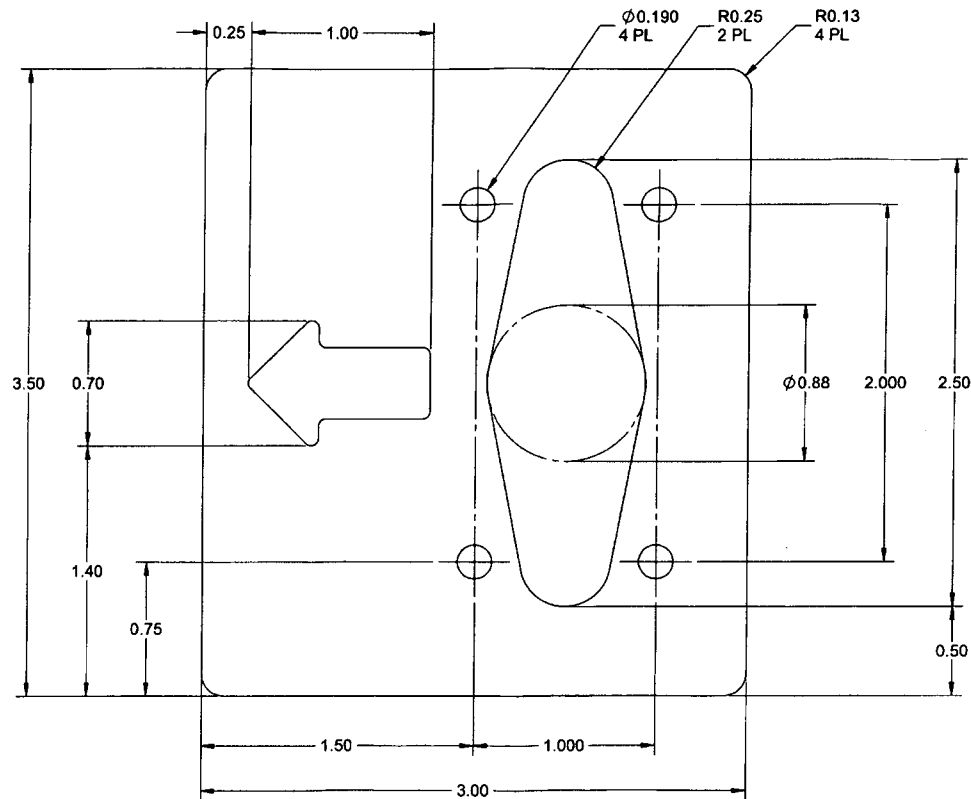


DETAIL A
4 PL

- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.080 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.080
 - 2) FINISH: ANODIZE BLACK OER MIL-A-8625, TYPE II, CLASS II
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.05 lbs

RELEASED
2014-11-06

APPROVED	DESIGN	ML	DART AEROSPACE LTD	
	DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	AP	DRAWING NO.	REV. B
	MFG. APPR.	JLM	D5092	SHEET 2 OF 3
	APPROVED	MP	TITLE	SCALE
	DE APPR.	DS-#	DOUBLER	NTS
DATE		14.07.07	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



D5092-1 TEMPLATE

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.1
- 7) WEIGHT: 0.03 lbs
- 8) PROFILE ALL NON DIMENSIONED FEATURES PER CAD FILE D5092-3-REVB.DXF
- 9) GRAIN DIRECTION NOT CRITICAL

APPROVED

DESIGN	ML	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	JLM	D5092	SHEET 3 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	DOUBLER	NTS
DATE	14.07.07	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2014-11-06
AM



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27864**

Purchase Order Date 3/23/2015

PO Print Date 3/23/2015

Page Number 1 of 3

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Buyer

Chantal Lavoie

Vendor Phone

613-446-4544

Customer POID

Customer Tax #

10127-2607

Ship To Contact

Terms

Net 30

Ship To Phone

Currency

CAD

Ship Via:

VENDOR'S TRUCK

FOB

FCA - (Free Carrier)

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	130061	D4726-1 HANDLE	3/26/2015 Yes 3/26/2015		10.00	\$2.70	\$27.00
	FINISH:HARD BLACK ANODIZE PER MIL-A-8625F TYPE III CLASS 2						
Line Total:							\$27.00
2	130533	D5092-041 DOUBLER ASSEMBLY	3/26/2015 Yes 3/26/2015		12.00	\$1.25	\$15.00
	FINISH:HARD BLACK ANODIZE PER MIL-A-8625F TYPE II CLASS 2						
Line Total:							\$15.00

SP15-03-26

Note:

3/23/2015



A.T.G. Industries Inc.
 731, rue Industrielle Rd.
 PLATING DEPARTMENT
 Rockland, On K4K 1T2
 Canada
 Ph: (613) 446-4544
 Fax: (613) 446-4556

Pack List

Number: 63622

Date: 26-Mar-15

To

DART AEROSPACE LTD
 1270 ABERDEEN ST.
 HAWKESBURY, ON K6A 1K7
 Canada

Ship To

DART AEROSPACE LTD
 1270 ABERDEEN ST.
 HAWKESBURY, ON K6A 1K7
 Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
10 ea	Part: D4726-1 HANDLE HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20150240	Rev:	
	PO: PO27864	Line:	
12 ea	Part: D5092-041 DOUBLER ASSEMBLY BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 Job: 20150241	Rev: B	
	PO: PO27864	Line:	SPS-03-26-
2 ea	Part: 646.3810 HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20150242	Rev: N/C	
	PO: PO27864	Line:	
8 ea	Part: 647.3916 HARD ANODIZE AS PER MIL-A-8625 TYII, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20150243	Rev:	
	PO: PO27864	Line:	
14 ea	Part: 647.3917 DOUBLER HARD ANODIZE MIL-A-8625 TY III CL 2 PRIME MIL-P-23377J TYPE I CLASS N PRIMER SUPPLY CUSTOMER Job: 20150244	Rev: C	
	PO: PO27864	Line:	



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63622

Date: 26-Mar-15

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

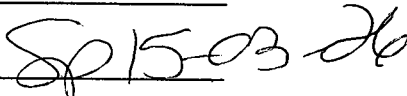
DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via
Quantity	Description	
	Certificate of Conformance	
	A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.	
	ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY	
	DATE : <u>26/3/15</u>	
	CERTIFIED SIGNATURE : <u></u>	
	RECEIVER SIGNATURE : <u></u>	